



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D3043-041
Job Sheet 209394



Part No: D3043-041

Job Qty: 8 pcs

Part Name: Step Weldment LH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/28/20

Job Tracking No:

Due Date: 11/24/20

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV A IPP Rev :A New Issue JLM 05-11-01

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Lead Time	Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier			
100	Large Fab - Steps - 1	8 pcs	11/21/20		0.00	2.00	Large Fab - 1			SEP 4 2020
							Large Fab - 10			
							Large Fab - 2			
							Large Fab - 3			
							Large Fab - 4			
							Large Fab - 5			
							Large Fab - 6			
							Large Fab - 7			
							Large Fab - 8			
							Large Fab - 9			
							Large Fab - 11 (Various)			
							Large Fab - 12			
110	QC 5	8 pcs	11/21/20		0.00	0.00	QC 5 - 10			SEP 09 2020
							QC 5 - 12			
							QC 5 - 17			
							QC 5 - 18			
							QC 5 - 19			
							QC 5 - 22			
							QC 5 - 24			
							QC 5 - 3			
							QC 5 - 43			
							QC 5 - 49			
							QC 5 - 51			
							QC 5 - 58			
							QC 5 - 68			
							QC 5 - 9			
							QC 5 - 50			
							QC 5 - 30			
							QC 5 - 40			
							QC 5 - 61			
							QC 5 - 81			

DART

AEROSPACE

Container No: S298554

D3043-041

No: 209394

al No/Batch: S298554

ion:

ctor:

Date:

uctions: Various STC's

Date: 09/04/20

Dart Aerospace Ltd.

1270 Aberdeen Street

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CANADA

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Container No: S298554



Part: D3043-041

Job No: 209394

Serial No/Batch: S298554

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 09/04/20

				QC 5 - 82	
120 Large Fab - Steps - 2 - B4B	8 pcs	11/23/20	0.00 5.33	Large Fab - 1 - B4B	
				Large Fab - 10 - B4B	
				Large Fab - 2 - B4B	
				Large Fab - 3 - B4B	
				Large Fab - 4 - B4B	
				Large Fab - 5 - B4B	
				Large Fab - 6 - B4B	
				Large Fab - 7 - B4B	
				Large Fab - 8 - B4B	
				Large Fab - 9 - B4B	
				Large Fab - 11 - B4B (Various)	
				Large Fab - 12 - B4B	
130 QC 9	8 pcs	11/23/20	0.00 0.00	QC 9 - 10	
				QC 9 - 18	
				QC 9 - 24	
				QC 9 - 43	
				QC 9 - 50	
				QC 9 - 9	
140 QC 5	8 pcs	11/23/20	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
				QC 5 - 82	
150 Handfinish - 1-1 Chemical-B4B	8 pcs	11/23/20	0.00 1.78	Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	

CC 9/11/20

DAS
24
9-89

SEP 14 2020

DAS
24
9-89

SEP 14 2020

160 Large Fab - Steps - 3 - B4B	8 pcs	11/23/20	0.00 4.00	Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
				Large Fab - 1 - B4B	
				Large Fab - 10 - B4B	
				Large Fab - 2 - B4B	
				Large Fab - 3 - B4B	DAS
				Large Fab - 4 - B4B	24
				Large Fab - 5 - B4B	9-89
				Large Fab - 6 - B4B	
				Large Fab - 7 - B4B	
				Large Fab - 8 - B4B	
				Large Fab - 9 - B4B	
				Large Fab - 11 - B4B (Various)	
				Large Fab - 12 - B4B	
170 QC 10	8 pcs	11/23/20	0.00 0.00	QC 10 - 10	
				QC 10 - 18	
				QC 10 - 24	
				QC 10 - 43	
				QC 10 - 50	
				QC 10 - 58	
				QC 10 - 9	
				QC 10 - 68	
				QC 10 - 81	
180 QC 5	8 pcs	11/23/20	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
				QC 5 - 82	
200 Handfinish - 6-1- Touch Up- B4B	8 pcs	11/23/20	0.00 1.33	Handfinish - 6 - 1 - B4B	
				Handfinish - 6 - 2 - B4B	
				Handfinish - 6 - 3 - B4B	
				Handfinish - 6 - 4 - B4B	
				Handfinish - 6 - 5 - B4B	
				Handfinish - 6 - 6 - B4B	
				Handfinish - 6 - 7 - B4B	
				Handfinish - 6 - 8 - B4B	
				Handfinish - 6 - 9 - B4B	
				Handfinish - 6 - 10 - B4B	
				Handfinish - 6 - 11 - B4B	
				Handfinish - 6 - 12 - B4B	
				Handfinish - 6 - 13 - B4B	
				Handfinish - 6 - 14 - B4B	

Plex 4/28/20 1:54 PM Dart.lajeunesse.marie

					Handfinish - 6 - 15 - B4B	
					Handfinish - 6 - 16 - B4B	
					Handfinish - 6 - 17 - B4B	
					Handfinish - 6 - 18 - B4B	
					Handfinish - 6 - 19 - B4B	
					Handfinish - 6 - 20 - B4B	
					Handfinish - 6 - 21 - B4B	
					Handfinish - 6 - 22 - B4B	
1254469.						
210 Powdercoat - 1 White GI(A)-	8	11/23/20	0.00 2.00		Powdercoat - 1 - B4B	
B4B	pcs				Powdercoat - 2 - B4B	
					Powdercoat - 3 - B4B	
					Powdercoat - 4 - B4B	
START: 2.35. O.V.T. 3.30 FINISH: 3.05.					Handfinish - 3 - 1 - B4B	
220 Handfinish - 3-1- WingWalk-	8	11/24/20	0.00 4.00		Handfinish - 3 - 2 - B4B	
B4B	pcs				Handfinish - 3 - 3 - B4B	
					Handfinish - 3 - 4 - B4B	
					Handfinish - 3 - 5 - B4B	
230 QC 3	8	11/24/20	0.00 0.00		QC 3 - 10	
	pcs				QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 68	
					QC 3 - 9	
					QC 3 - 40	
					QC 3 - 19	
					QC 3 - 43	
					QC 3 - 24	
					QC 3 - 61	
					QC 3 - 81	
					QC 3 - 82	
					QC 3 - 87	
240 Packaging 3-1 - Stock - B4B	8	11/24/20	0.00 0.00		Packaging 3 - 1 - B4B	
	pcs				Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	

				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	DAS
				Packaging 3 - 25 - B4B	72 OCT 01 2020
				Packaging 3 - 26 - B4B	9-89
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	DAS OCT 01 2020
250 QC 21 - SA	8 pcs	11/24/20	0.00 0.00	QC 21 - SA - 21	DAS 21
				QC 21 - SA - 70	9-89
				QC 21 - SA - 53	

Part Op 100 - (Fabricate per Drwg)1-Cut D2622-120 extrusion to 120.00" long as per Dwg D3043 using cutting table setup
 Descriptions: DT8185-G 2-Debur and bevel ends for welding
 120 - (Fabricate per Drwg)1-Weld 1 End Cap & Mounting Lugs as per QSI 004 & Dwg D3043 Using DT8802 AR AL ROD
 Batch: 139019 2-Grind Fwd End Cap weld flush
 130 - QC9- Inspect visual per QSI004- Fusion Welds)
 140 - (QC5- Inspect part completeness to step on W/O)
 150 - (Chemical Conversion Coat per QSI005 4.1)
 160 - (Fabricate per Drwg)1-1-Weld 1 End Cap as per QSI 004 & Dwg D3043 AR AL ROD Batch: _____ 2-
 Inspect for foreign object as per QSI 024 3-Grind Fwd End Cap weld flush
 170 - (QC10- Inspect visual per QSI004- ground welds)
 180 - QC5- Inspect part completeness to step on W/O)
 200 - (Touch up alodine)
 210 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum)START TIME: _____ OVEN TEMPERATURE: _____
 FINISH TIME: _____
 220 - (Wing Walk as per dwg QSI005 4.4 Batch _____)
 230 - (QC3- Inspect Part Finish)
 240 - (Identify as per dwg & Stock Location: _____)
 250 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2622-120C	Step Extrusion	8 pcs (1 ea)	100-Large Fab - Steps - 1	5269726
D2734	Step End Plate	16 pcs (2 ea)	100-Large Fab - Steps - 1	5289571
D3040-1	Mounting Lug	16 pcs (2 ea)	100-Large Fab - Steps - 1	5266117
D3040-3	Mounting Lug	16 pcs (2 ea)	100-Large Fab - Steps - 1	5268043

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Steps - 1	D2622-120C	8	267	0
	D2734	16	60	0
	D3040-1	16	80	0
	D3040-3	16	68	0

Part Specifications

Specifications could not be found.

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					